

Date: Monday, 9/10/2007 1:31:31 PM  
 User: Kim Johnston

## Process Sheet

*SPR 0810107*

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY  
 Job Number : 34513 -2  
 Estimate Number : 10290  
 P.O. Number :  
 This Issue : 9/10/2007 S.O. No. :  
 Prsht Rev. : NC Part Number : D3121144  
 First Issue : 11 Type : MACHINED PARTS Drawing Number : D3121 REV D  
 Previous Run : 31729 Project Number : N/A  
 Material :  
 Due Date : 9/30/2007 Qty: 8 Um: Each  
 Written By : *SA 07.09.11*  
 Checked & Approved By :  
 Comment : Est Rev Pick: A 04.02.18 New issue KJ/DS

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M174B1000X02000 17-4 SS Bar



Comment: Qty.: 0.3864 f(s)/Unit Total: 3.0912 f(s)

Material: 17-4 SS Bar per AMS 5604/5643

(M17-4-B1-000x02-000)

Identify for D3121-114

Batch: *M103089*

*SA 07.11.13*

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: (1.000" x 2.000") 4.425" long

*SA 07.11.13*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-114 as per Folio FA330 and Dwg D3121 Identify as D3121-114

2-Deburr

3-Scribe batch number

*SA 07.11.14*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SA 07.11.17*

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 34513

Part Number: D3121144

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6.0

D312121

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3121-21

Bolt

B 23455 (2)

B 34522 (7)

B 37478 (6)

(X)

7.0

D3121241

Bearing Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3121-241 Bearing Ass

B 21855A (2)

B 34523 (10)

B 37475 (4)

(X)

8.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble D3121-143 as per Dwg D3121.

08/02/26 (3)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 08/02/26

(3)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 233

8/2/26 SD

(3X)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/27

(3)

SD 2008/2/27

(3)

Job Completion



DART AEROSPACE LTD		Work Order:	34513
Description: Bracket		Part Number:	D3121-114
Inspection Dwg: D3121	Rev: D	Page 1 of 2	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	0.080	✓			
0.300	+/-0.010	0.301	✓			
R0.375	+/-0.010	R0.375	✓			
1.54	+/-0.030	1.540	✓			
0.350	+/-0.010	0.350	✓			
R0.250	+/-0.010	R0.250	✓			
1.800	+/-0.030	1.800	✓			
Ø0.392	+0.002/-0.000	Ø0.393	✓			
Ø0.201	+0.005/-0.000	Ø0.201	✓			
0.100	+/-0.010	0.095	✓			
2.540	+/-0.010	2.540	✓			
1.590	+/-0.010	1.593	✓			
0.160	+/-0.010	0.160	✓			
0.400	+/-0.010	0.410	✓			
1.220	+/-0.010	1.230	✓			
1.600	+/-0.010	1.603	✓			
3.80	+/-0.030	3.804	✓			
1.800	+/-0.010	1.801	✓			
R0.500	+/-0.010	R0.500	✓			
0.130	+/-0.010	0.123	✓			
3.41	+/-0.030	3.410	✓			
3.65	+/-0.030	3.630	✓			
2.24	+/-0.030	2.210	✓			
45°	+/-0.1°	45°	✓			
R0.250	+/-0.010	R0.250	✓			
3.97	+/-0.030	3.966	✓			
R0.38	+/-0.030	R0.380	✓			
Ø0.392	+0.002/-0.000	Ø0.393	✓			
Ø0.201	+0.005/-0.000	Ø0.201	✓			
0.100	+/-0.010	0.095	✓			
0.268	+/-0.010	0.268	✓			
R0.260	+/-0.010	R0.260	✓			
0.080	+/-0.010	0.078	✓			
0.300	+/-0.010	0.301	✓			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.01.07	3	1 SCRAP.		Poped out of Fixture.	<i>[Signature]</i>			

NOTE: Date & initial all entries